

(12) UK Patent Application (19) GB (11) 2 345 262 (13) A

(43) Date of Printing by UK Office 05.07.2000

(21) Application No 0006111.9

(22) Date of Filing 15.09.1998

(30) Priority Data

(31) 08931773 (32) 16.09.1997 (33) US

(86) International Application Data

PCT/US98/19160 En 15.09.1998

(87) International Publication Data

WO99/14029 En 25.03.1999

(51) INT CL⁷

B29C 45/26 45/37

(52) UK CL (Edition R)

B5A ALX ANA AT14E A1R168 A1R214H A1R413 A2C
A2E10 A2E4H A2E4K A20T14 A3D1X

(56) Documents Cited by ISA

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(58) Field of Search by ISA

U.S. : 425/128, 163, 190, 249

(71) Applicant(s)

Strum, Ruger & Company Inc
(Incorporated in USA - Delaware)
Lacey Place, Southport, CT 06490,
United States of America

(74) Agent and/or Address for Service

Cruikshank & Fairweather
19 Royal Exchange Square, GLASGOW, G1 3AE,
United Kingdom

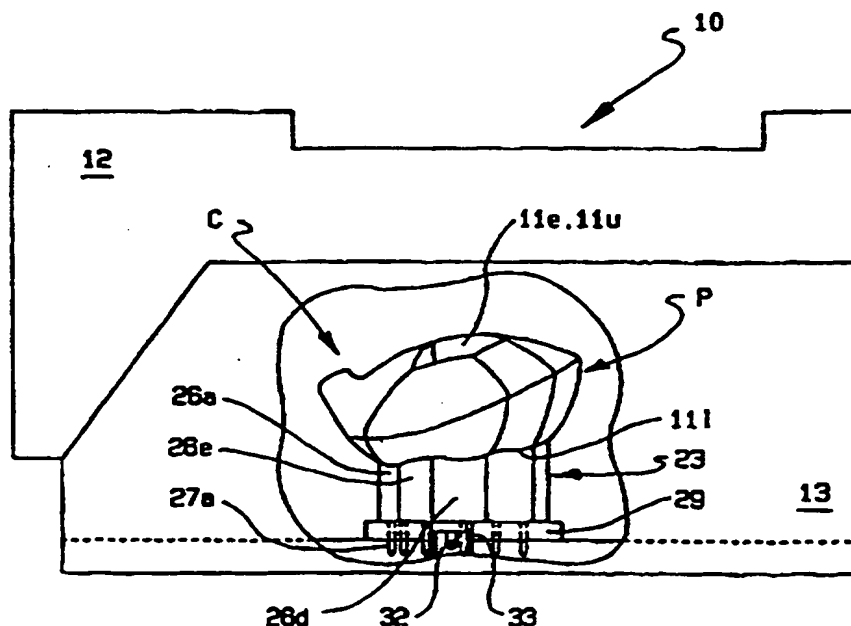
(72) Inventor(s)

Thomas, E. Yost
Paul, N. Latulippe Jr

(54) Abstract Title

Injection mold apparatus for producing a pattern and method of mold use

(57) An injection mold (10) for forming a pattern (P) for use in investment casting having mold sections (12, 13) carrying two pattern-forming surfaces (18, 19) and a translatable third pattern-forming element (21) movable on a mold section (16). The mold also includes an inner core (23). Parting lines (36, 37) are located at inconspicuous locations by sizing and shaping the mold sections. The method of use of the injection mold includes employing an arrangement for facilitating lower mold section (13) and for raising the inner core to facilitate its removal.



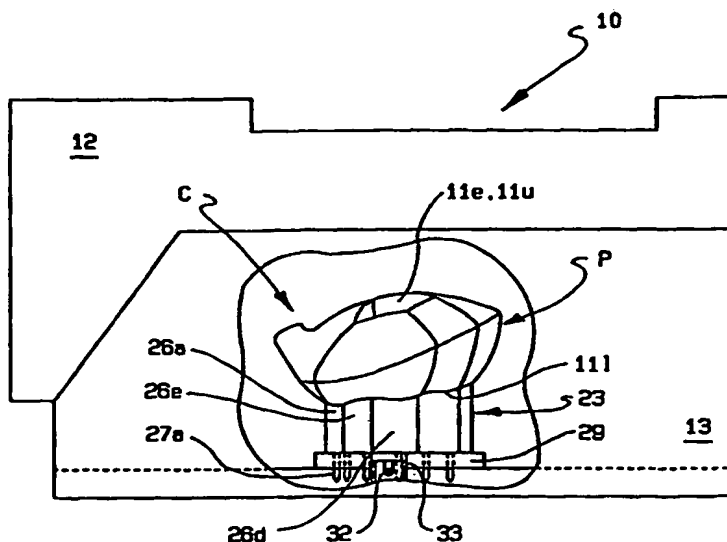
GB 2 345 262 A



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B29C 45/37	A1	(11) International Publication Number: WO 99/14029 (43) International Publication Date: 25 March 1999 (25.03.99)
(21) International Application Number: PCT/US98/19160 (22) International Filing Date: 15 September 1998 (15.09.98) (30) Priority Data: 08/931,773 16 September 1997 (16.09.97) US (71) Applicant: STURM, RUGER & COMPANY, INC. [US/US]; Lacey Place, Southport, CT 06490 (US). (72) Inventors: YOST, Thomas, E.; 3140 Montana Drive, Prescott, AZ 86301 (US). LATULIPPE, Paul, N., Jr.; 485 South Reed Road, Chino Valley, AZ 86323 (US). (74) Agents: McKENNEY, Charles, E. et al.; Pennie & Edmonds LLP, 1155 Avenue of the Americas, New York, NY 10036 (US).		(81) Designated States: CN, GB, JP, KR, MX. Published <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>

(54) Title: INJECTION MOLD APPARATUS FOR PRODUCING A PATTERN AND METHOD OF MOLD USE



(57) Abstract

An injection mold (10) for forming a pattern (P) for use in investment casting having mold sections (12, 13) carrying two pattern-forming surfaces (18, 19) and a translatable third pattern-forming element (21) movable on a mold section (16). The mold also includes an inner core (23). Parting lines (36, 37) are located at inconspicuous locations by sizing and shaping the mold sections. The method of use of the injection mold includes employing an arrangement for facilitating lower mold section (13) and for raising the inner core to facilitate its removal.

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INJECTION MOLD APPARATUS FOR
PRODUCING A PATTERN AND METHOD OF MOLD USE

This application is a continuation-in-part of an application filed July 10, 1997 entitled "Injection Mold For Producing A Pattern And Method of Mold Use", Serial No. 08/891,435 which in turn was a continuation of U. S. Application Serial No. 08/662,900 filed June 12, 1996 of the same title.

10

Background of the Invention

Aluminum molds for making wax patterns have been in use for years. Combination aluminum and epoxy molds have also been used. Epoxy mold parts have the drawback of wearing after repeated use and of being easily damaged during the handling required to carry out repeated molding operations. Additionally, it is well known that aluminum molds have superior heat transfer relative to epoxy molds, thereby reducing dwell time for wax pattern production and overall cycle time.

20

Where molded parts have included an intricate interior cavity, a plurality of mold sections and cores have been required. The mold parts and cores require handling to accomplish assembly and disassembly. Further, in the molding of demanding shapes such as golf club heads parting lines have presented problems requiring trimming and reworking wax patterns. Prior wax patterns for making golf club heads are disclosed in U. S. Patent Nos. 5,204,046 and 5,417,559.

25

30

Summary of the Invention

In summary, the present invention comprises a multi-section mold including an inner cluster core which novel mold is shaped and proportioned to facilitate handling during molding operation. Mold manipulation by hand is limited to sliding and translating of mold sections and the removal and replacement of the cluster core.

35

Preferably, the mold is connected to and operated with a mold press which includes a work station and a preparation station into which a lower mold portion is slidably mounted with inner cluster core in place and the upper mold section
5 is lowered against the lower section. After injection of wax and cooling, the upper section is raised, the lower section is slidably moved out of the work station to the preparation station and a third mold portion is translated in its open position. Finally, the cluster core is removed.

10

As a feature, it is contemplated that, as the lower section is moved out of the work station, the core along with the wax pattern may be automatically raised to facilitate pattern and core removal. The mold is made of aluminum.

15

Brief Description of the Drawings

Fig. 1 is a side elevational view of the upper and lower mold portions assembled with a removable core cluster;

20

Fig. 2 is a perspective view of the upper and lower portions separated with the core cluster removed;

Fig. 3 is a perspective view of the lower mold portion showing the lower mold cavity and slidable third mold portion
25 in its closed position;

Fig. 3A is a view similar to Fig. 3 with the third mold portion slid open;

30

Fig. 4 is a perspective view of the upper mold portion;

Fig. 5 is a plan view of the pattern mold with parting lines and with the cluster of cores therein and with the wax pattern, not shown, surrounding the core cluster;

35

Fig. 6 is a front elevational view of the pattern mold including parting lines with the wax pattern not shown;

Fig. 7 is an expanded perspective view of the core cluster and mount ring;

Fig. 8 is a front elevational view of the press and mold apparatus with the lower mold in its injection position; and

Fig. 9 is a view similar to Fig. 8 with the lower mold in its assembly preparation station;

10 Fig. 10 is a front elevational perspective view of an alternative embodiment of the mold apparatus of the invention including the upper mold, the lower mold and the lower mold guide track;

15 Fig. 11 is a side elevational view partially broken away showing the apparatus assembled and one of the track's slotted rails;

Fig. 12 is a view similar to Fig. 11 in which the upper mold has been raised and the lower mold partially moved along the track;

Fig. 12a is an enlarged side elevational view of the track rail of Fig. 12;

25

Fig. 13 is a top view of the lower mold;

Fig. 14 is a bottom view of the lower mold;

30 Fig. 15 is a bottom view of the upper mold;

Fig. 16 is a side view of the lower mold;

Fig. 17 is a perspective view of the portable core cluster stand with upstanding pins;

Fig.18 is a perspective view of the stand with the cluster mounted thereon;

Fig. 19 is a perspective view of the stand with the cluster mounted thereon and the crank operated to lower the center core unit;

Fig. 20 is a perspective view of the center core unit; and

10

Fig. 20a is the side elevational view of the center core unit including its prong slot with the crank pin in engagement with the prong slot.

15

Description of the Preferred Embodiments

In the Figures, pattern forming mold unit 10 functions to mold a wax molded pattern P having an exterior surface 11e and an interior surface 11i (see Fig. 5) which pattern P is used in investment casting of a metal part such as a portion of golf club head (see Figs. 1, 5 and 6). Mold 10 includes four (4) pattern-shape determining portions which create mold cavity C: The first portion is upper mold portion 12; the second is lower mold portion 13; and the third is a slidable mold portion 16 mounted for horizontal slidable movement on lower portion 13 and the fourth portion is the core cluster 23 (see Figs. 1, 3, 3A and 4). Upper mold portion 12 includes cavity surface 18 which defines upper surface 11u of molded pattern P (not shown) (see Fig. 5). The lower mold portion 13 includes a cavity surface 19 which defines a portion 11l of the lower surface of the molded pattern P. Finally, face surface 21 of slidable mold portion 16 defines the remainder of the exterior surface of pattern P. Face surface 21 includes groove forming stand ups 21g.

35

Mold 10 also includes a core cluster 23 which is composed of six (6) core sections 26a-f with core section 26f

being the center core section (see Fig. 5). Each core section 26a-f has receiving pins 27a-f respectively (Fig. 1). The core cluster 23 is positioned in mount ring 29 having holes 31a-f for receiving pins 27a-f. Attached to ring 29 and extending from it is locator prong 32 which fits into mold slot recess 33 to locate core cluster 23.

Referring now to Figs. 2, 3 and 4, the size and shape of pattern P is defined by upper mold portion cavity surface 18, lower mold portion cavity surface 19 and face surface 21 of slidable mold portion 16. The parting lines created by mating of cavities 18, 19 and face surface 21 are crown periphery parting line 36 (see Fig. 5) and face periphery parting line 37 (see Fig. 6). These parting lines 36, 37 are located on pattern P such that they are inconspicuous and therefore little or no reworking of molded pattern P is necessary to assure that the mold product made using pattern P has no conspicuous imperfections. Also shown is wax injection port 20.

20

Turning to Figs. 8 and 9, mold 10 portions 12 and 13 are positioned for use in a mold press 40 having reciprocating platen 42 movable up and down. Upper mold portion 12 is attached to platen 42. Below reciprocating platen 42 press base 41 supports lower mold portion 13 shown resting in its injection position in Fig. 8 and in its assembly position in Fig. 9).

Lower mold portion 13 is mounted on guide rails (not shown) for ease of horizontal translation on base 42 from its injection station (IS) to its assembly preparation station (PS).

In the operation of mold press 40, lower mold portion 13 is translated horizontally by an operator to preparation station (PS) where the slidable mold portion 16 is moved away from mold surface 19. Cluster of cores 23 are placed in

mount ring 29 which ring 29 is mounted and located by insertion of prong 32 in recess 33 in lower mold portion 13. Next, slide mold portion 16 is moved to its injection position. Lower mold portion 13 is translated to its
5 injection station (IS).

Reciprocal platen 41 carrying upper mold portion 12 is then lowered to engage with lower mold portion 13. Alignment pins 24, 25 on upper portion 12 enter alignment holes 34, 35
10 of lower portion 13. The hosel hole core pin (not shown) is inserted in cavity C to form hosel opening 38 (Fig. 4). Pressure is exerted to hold the mold portions 12, 13 together as wax is injected in the pattern forming cavity C.

15 After a suitable cooling period for the wax to solidify, the hosel core pin is retracted and then the reciprocal platen 41 carrying the upper mold portion 12 is raised and the lower mold portion 13 is translated from the injection station (IS) to the preparation station (PS). As the lower
20 mold section is retracted toward the operator, the core cluster is moved automatically upward about one-half an inch by means of a wedge or cam device not shown, thereby improved ease of core cluster disassembly. Slide 16 is moved away from both cluster 23 and pattern P. The mount ring 29
25 including pattern P is then grasped by operator, lifted out of the mold 13 and placed on a stand (not shown). A second mount ring and core cluster unit are placed in lower mold portion 13, mold portion 16 is moved into molding position, lower mold portion 13 translated back to its injection
30 station (IS) and the press mold 40 is ready for the next cycle. The operator holds the wax pattern in one hand and lifts out the core cluster pieces 26a-f, then the core cluster 23 is reassembled for use in the next injection cycle.

35

An identification piece with marking on it may be placed in mold cavity C causing corresponding markings to appear on the wax pattern P.

5 Turning to Figs. 10 to 12, mold press apparatus 50 operates to position mold sections described above for injection, for disassembly and reassembly which mold press 50 apparatus has an upper vertically reciprocal platen 51 to which the upper mold section 52 with beak section 52a is
10 attached. Mold press apparatus 50 further includes a lower mold section 53 which is reciprocal in guide track 55 once separated from its upper mold section 52 from an injection position to a retracted position for disassembly and assembly. Movement of lower mold section 53 away from its
15 upper mold section 52', as guided by track 55, is limited by stop piece 65. Pin hosel 58, which extends during operation into and occupies opening 54 (Fig. 15) to create a cylindrical void in the pattern being formed, is attached to a double acting air cylinder-piston unit 67. Cylinder-piston
20 unit 67 is mounted on platen 51. Track 55 includes spaced-apart guide left rail 56 and right rail 57 (as viewed in Fig. 10) with each rail 56, 57 including guide slots 68a, 68b forward upper guide slots 69a, 69b, forward lower guide slots 71a, 71b and spring-loaded ramp 56a (Fig. 12a). Spring-
25 loaded ramp 56a having slot 79a is swingable in rail pocket 72a.

Lower mold section cross bar 59 positioned in opening 62 of lower mold section 53 (Fig. 16) has cross bar 59 with
30 right stud end 60 and left stud end 61 (not shown) which ends 60, 61 ride in guide slots 68a, 68b and 71a, 71b (Fig. 12a). Turning back to Fig. 12a, bar stud end 60 rides in a path indicated by arrows A during lower mold 53 movement toward stop piece 65 in guide slot 68a until it enters slot 79a of
35 ramp 56a causing stud end 60 to be raised up into upper guide slot 69a and as it continues forward to pass into guide slot recess areas 87a, 87b. Stud end 60, under spring urging,

then drops down into lower slot 71a for return. As stud end 60 engages ramp lower surface 56s of ramp 56a during such return it raises ramp 56a and continues rearward through slot 68a.

5

Turning further to Fig. 16, lower mold section opening 62 houses support plate 63 which rides up and down on vertical rods 64a and 64b (not shown). Springs 65a, 65b urge plate 63 downwardly. Plate 63 engages and causes upward
10 movement of center core unit 88 during the withdrawal of lower mold section 53 to its disassembly/assembly station adjacent stop piece 65 and simultaneously shears injection sprue. Plate 53 is raised by bar stud ends 60, 61 travelling in guide slots as described above. The raising and lower of
15 plate 63 under action of cross bar 59 with its ends 60, 61 is accomplished by the inclined groove system of Fig. 12a serving stud end 60 and a similar groove system in rail 56 serving stud end 61, all as explained above.

20 Turning now to Figs. 13-16, lower mold section 53 includes air cylinder stand-off portion 53s, a slide mold section 70 riding in slide pocket 70p having face 70f and core 73. When upper mold section 53 is raised its beak section 52a releases slide mold section 70 allowing it to
25 move away from pattern (P) under force of a spring element (not shown). Lower mold section 53 further includes bottom surface 74 with a plurality of air (or other fluid) exit holes 76 arranged in rows 77a-e. Air exit holes 76 may be arranged in rows or any other pattern. Air exit holes 76 are
30 connected to an air manifold (not shown).

When the core 73 is placed in lower mold section 13, six (6) rare earth magnets 98 (Fig. 13), aligned with core pins 95a-f, magnetically attract pins 95a-f in assuring the pins
35 95a-f are properly seated in lower mold section 53 against plate 63 (Fig. 16).

In Figs. 17 and 18, a portable core cluster handling device 82 normally positioned on surface S of mold apparatus 50 (Fig. 10) includes body 83 with front panel 83f and top surface 83t. Upstanding pins 85 are mounted on top surface 83t and there is an opening 83o in top surface 83t to receive central core prong 86 of central core unit 88 (see Fig. 20). Device 82 has a crank 81 pivoted on pin 80 in front panel 83f. Crank 81 carries projecting cam pin 78 which projects through front face slot 75 into prong slot 86s. Pattern (P) is positioned on core cluster 73. Core 73 includes central core unit 88 which in turn also includes ring body 89 and central core 91. Ring body 89 includes holes 90 for receiving the pins 95a-f of core sections 94a-c (see Figs. 18, 19 and also Figs. 5 and 7).

15

In the operation of mold apparatus 50 and portable associated device 83, upon wax or other mold material injection into engaged mold sections 52, 53 through sprue hole (not shown) together with core pin 58 in place, pin 58 is withdrawn and upper platen 51 with its attached mold section 52, after a proper time delay, are raised. Preferably, this step of mold apparatus 50 and subsequent steps are automatically operated in a computer programmed control sequence. As upper mold section 52 moves up and away from lower mold slide section 70, mold slide section 70 is free under spring urging to move away from the molded pattern (P). Next, the operator grasps handle 53h and at the same time opens air handle valve 53v (Fig. 10) causing air to flow out lower mold bottom holes 76 providing an air cushion between the lower mold bottom surface 74 and the press table surface (S).

Lower mold section 53 is then pulled with ease on air cushion by the operator in direction D (Fig. 10). As lower mold section 53 moves toward stop piece 65, lower mold plate 63 is lifted due to the camming action of cross bar 59 with its stud ends 60, 61 as such stud ends 60,61 are cammed

upwardly in guide slots 68, 68b, 69a, 69b and 71a, 71b causing core unit 88 to rise up (Fig. 12a). The sprue (not shown) is severed as core unit 88 rises. When stud ends 60, 61 reach the ends of slots 69a, 69b they drop down through
5 recesses 87a, 87b under action of spring-loaded plate 63. Stud ends 60, 61 are then free to move under slots 71a, 71b as mold section 53 is pushed by the operator back to its position for mating with upper mold 52. Core unit 88, having been raised by plate 63, is then readily grasped by the
10 operator for removal. As core unit 88 is extracted the injection sprue is sheared off. Lubricant or cold air may be sprayed on the hosel pin 58 to reduce sticking.

The operator then places the wax pattern (P) with
15 the internal core cluster 73 on core cluster mount device 82. The center core 88 is extracted by operating crank 81. The projection pin 78 of crank 81 engages slot 86s of prong 86 to cause prong 86 to move downwardly as crank 81 is pushed down. As prong 86 is lowered by crank action, ring holes 90
20 accommodate upstanding pins 85 permitting downward movement until ring center cluster 89 is seated on device top surface 83f. Center core 88 is thereby separated from pattern (P) without the operator grasping pattern (P) which could cause its deformation. The remaining core sections are then
25 readily removed by hand and places them on a pedestal for assembly.

30

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WE CLAIM:

1. An injection mold for forming a pattern having an exterior surface and an interior surface which pattern is
5 useful in investment casting comprising

- 10 (a) a plurality of mold sections assembled for molding the pattern and disassembled to release the pattern; the assembly of such sections forming parting lines;
- 15 (b) the mold sections carrying a plurality of pattern forming mold elements for forming the exterior surface of the pattern which mold surface elements include
- 20 i) a first element having a first pattern-forming surface on a mold section therein;
- 25 ii) a second element having a second pattern forming surface on a mold section therein; and
- 30 iii) a translatable third pattern-forming element movable along a mold section;
- 35 (c) an inner core for defining the interior surface of the mold pattern; and
- (d) the mold sections being sized and shaped so that parting lines are placed on the mold pattern to locate the parting line imperfections in the mold pattern in the least conspicuous locations.

2. The injection mold of claim 1 in which the mold pattern is used for making a golf club wood-type head which pattern has a head crown periphery and a face periphery and in which one parting line is on the crown periphery of the 5 pattern head and another parting line is on the face periphery of the pattern head.

3. The injection mold of claim 1 in which one mold section is an upper section and another section is a lower 10 section and the inner core is on the lower section and includes a cluster of cores.

4. The injection mold of claim 3 in which the cluster of cores are mounted on a ring and prong device insertable 15 into a mold section.

5. The injection mold of claim 1 in which the mold sections are aluminum.

20 6. The injection mold of claim 3 in which the ring and prong devices are mounted for reciprocal vertical movement on lower mold section.

7. A mold press arrangement for supporting and moving 25 a pattern mold having an upper and a lower mold portion including a core cluster unit comprising

(a) a vertically reciprocal platen means carrying the upper mold portion;

30 (b) base means upon which the lower mold portion is translatable from an injection station to a preparation station; and

35 (c) core cluster unit lifting means located in the base means to lift the cluster unit when it is in its preparation station.

8. The mold press arrangement of claim 7 in which the lower mold portion includes a slidable element slidable to an open position to assist in removal of the core cluster from the lower mold portion.

5

9. An apparatus for forming a mold pattern comprising

a. an upper mold section;

10

b. a lower mold section movable along a surface;

c. a core cluster positioned in the lower mold section; and

15

d. guide track means for guiding the lower mold section during its transport from a molding position to a remote position for removal of the core cluster.

20

10. The apparatus of claim 9 having in addition a first cam means on the track means and a second cam means on the lower mold section which cam means causes the core cluster to move upwardly when the lower mold section is moved along the track means.

25

11. The apparatus of claim 9 having in addition fluid ejecting means for creating supply fluid between the lower mold section and the surface.

30

12. The apparatus of claim 9 having in addition a center core in the cluster core and a device for receiving the cluster core with a pattern on it and for separating the center core from the cluster core.

35

13. The apparatus of claim 9 in which the lower mold section includes magnet means to attract the core cluster toward the lower mold section.

5 14. A method of molding a pattern using a multiple section mold including an upper mold section, a lower mold section with a slide piece and a core cluster

- 10 a. providing an upper section for vertical reciprocity movement;
- 15 b. positioning the lower mold section including side piece and the core cluster on a horizontal control surface for translation movement;
- 20 c. providing a translatable lower mold section from a first molding position under the upper mold section to a second assembly position;
- 25 d. providing and fluid cushion under the lower mold section during translation;
- e. moving the lower mold section under and then engaging it to the upper mold section;
- 30 f. injecting material into the mold;
- g. thereafter translating the lower mold section on the horizontal control surface to its second position after elevating the upper mold section;
- 35 h. removing the core cluster; and

- i. placing the core cluster on a center core separation device.

15. The method of claim 14 having in addition the steps

5 of

- a. providing track means for controlling and guiding the lower mold section during such translation;
- b. providing guide means in the track means; and
- c. providing cam means on the lower mold section which ride in the guide means to raise the core cluster.

10

15

16. The method of claim 14 having in addition the steps

of

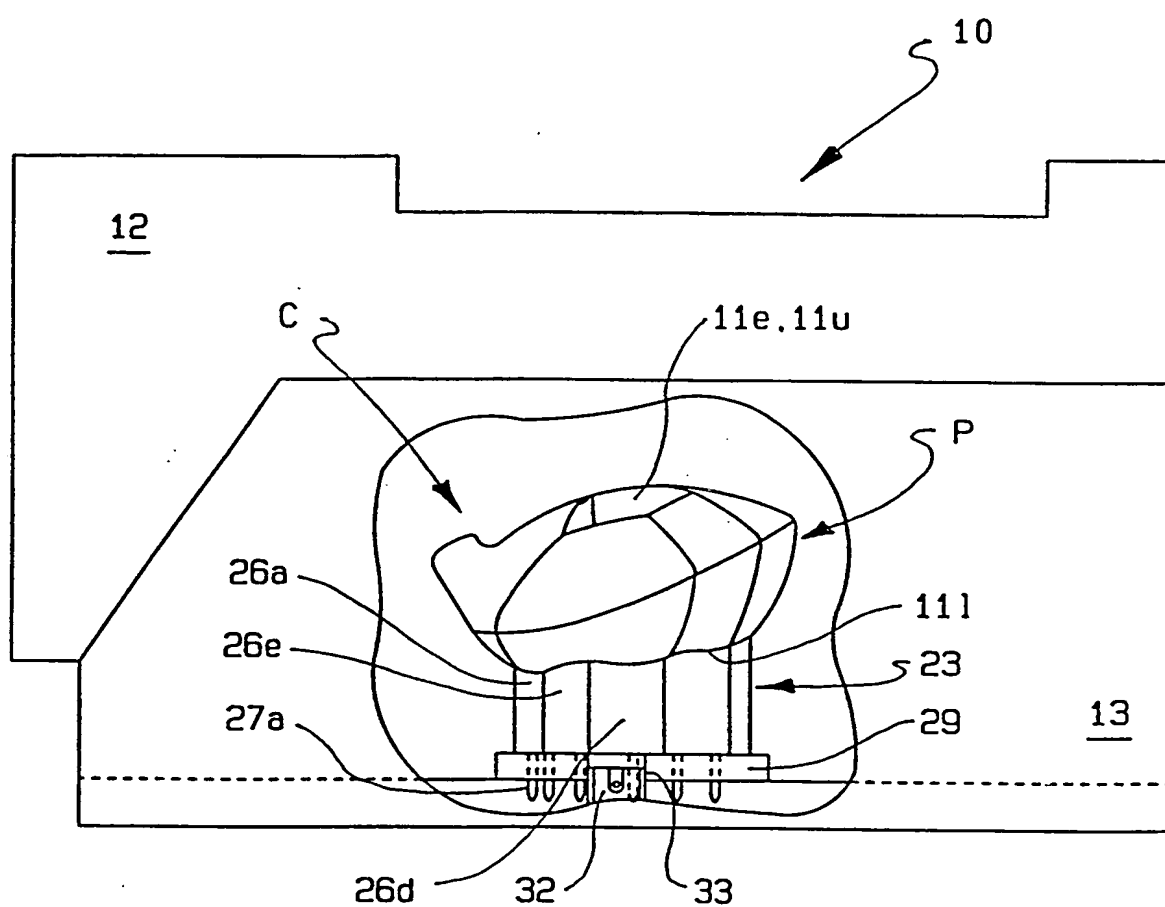
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- a. a core cluster having a center core unit;
- b. providing means for mounting the core cluster; and
- c. providing means for separating the center core unit from the core cluster.

25

17. The method of claim 14 having in addition a sprue
30 formed on the pattern and providing means for shearing off the sprue when the translatable lower mold section is moved from its first molding position to a second assembly position.

35 18. The method of claim 14 in addition providing a magnet in the lower mold section to attract the core cluster to the lower mold section.



2/14

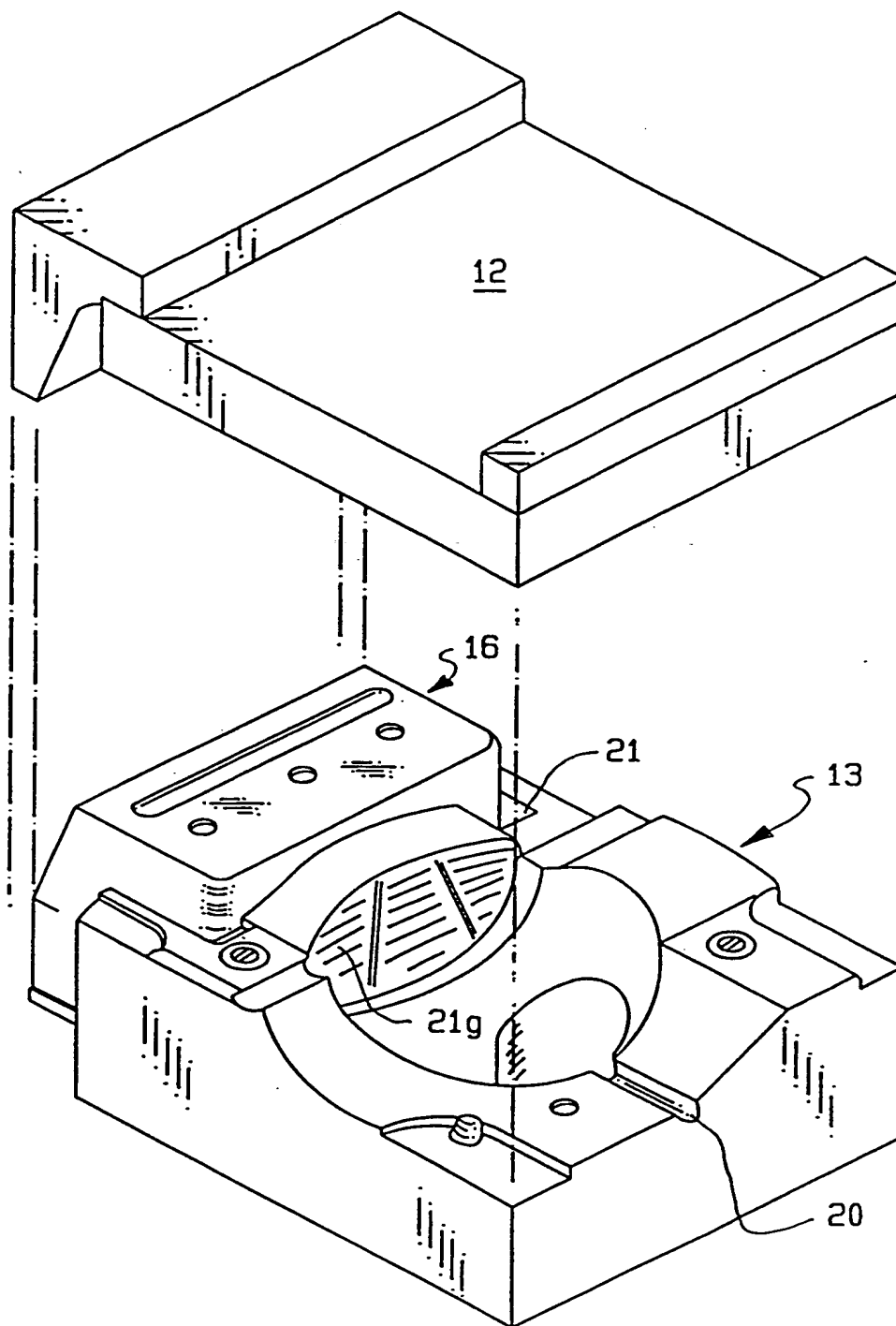


FIG. 2

3/14

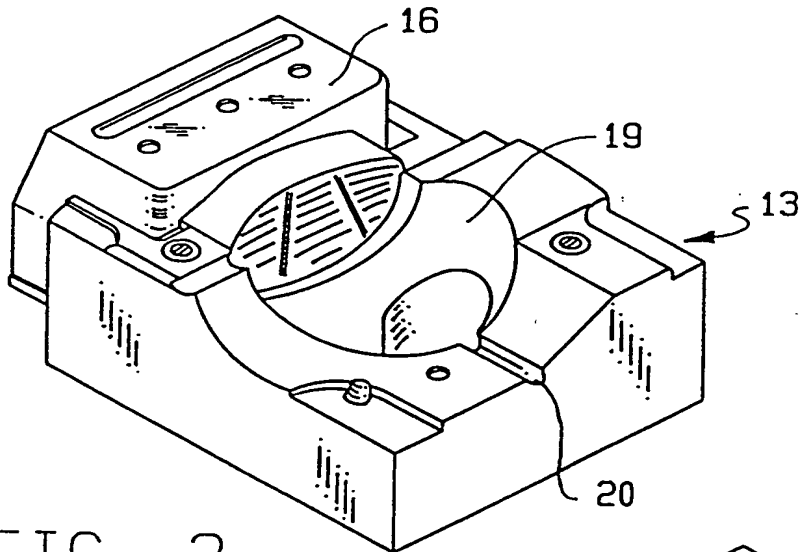


FIG. 3

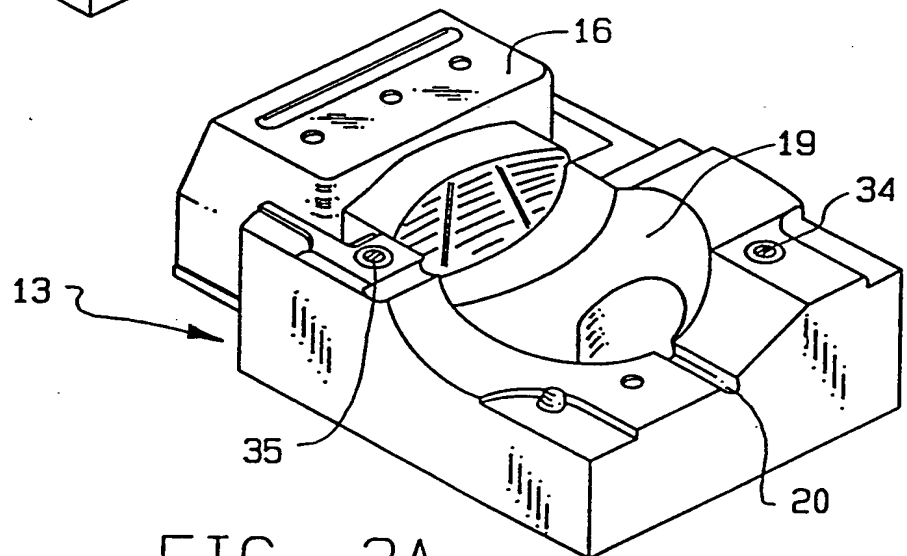


FIG. 3A

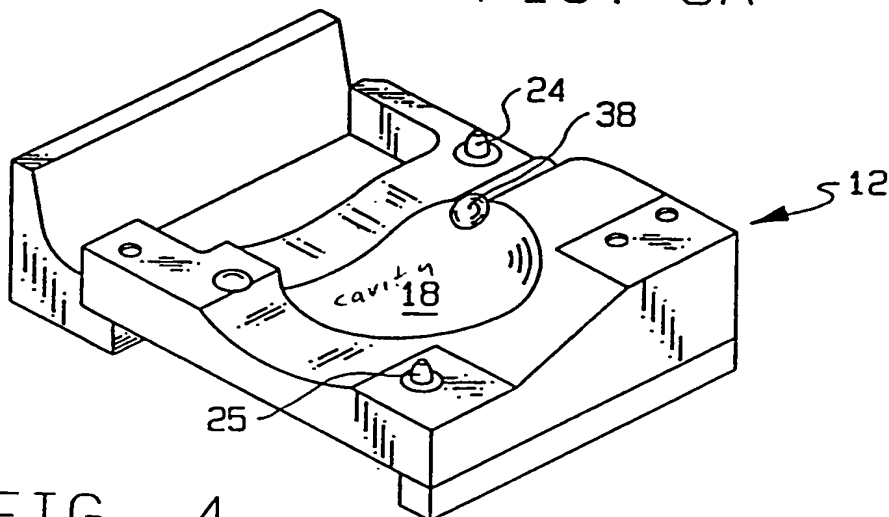


FIG. 4

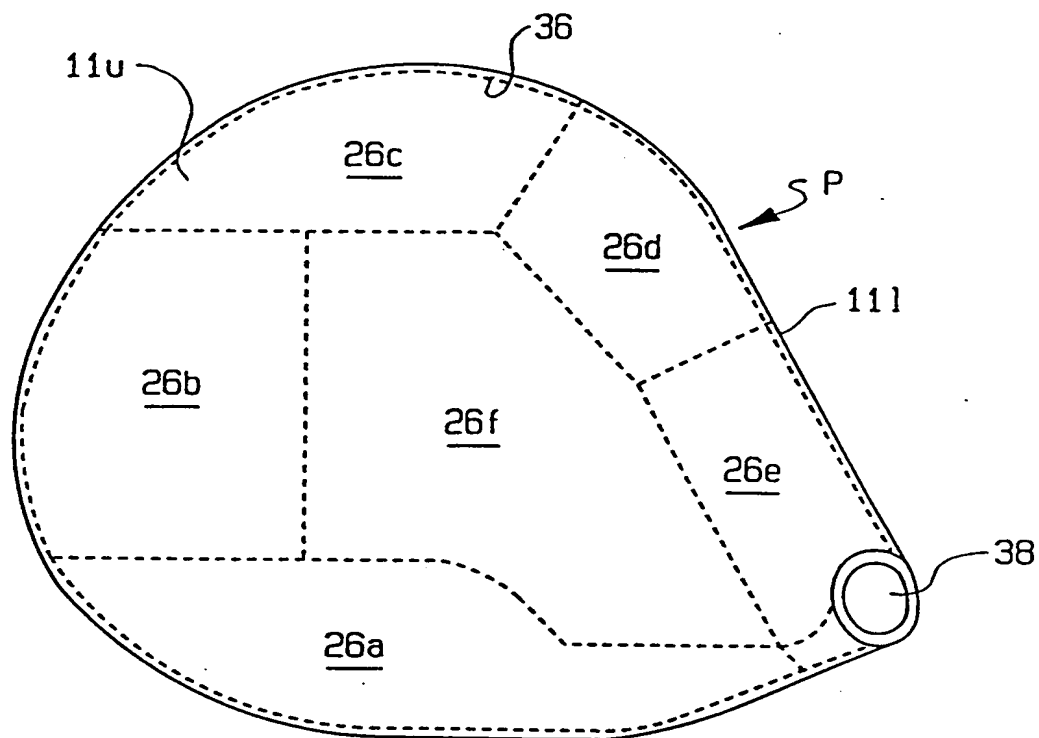


FIG. 5

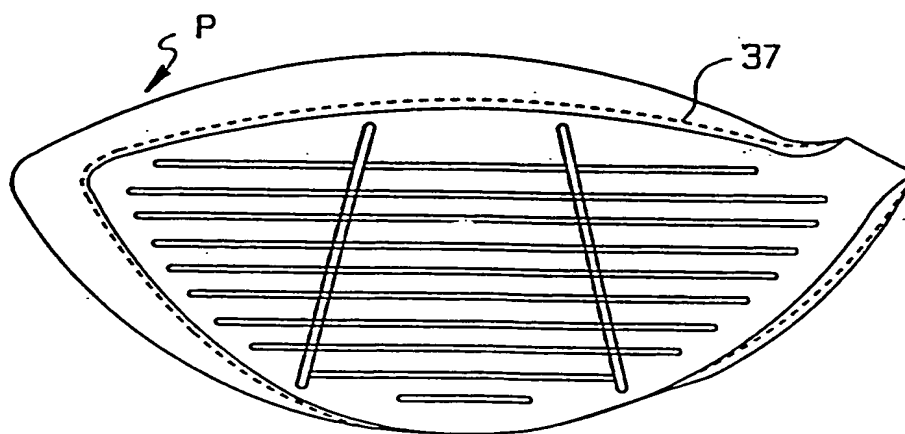


FIG. 6

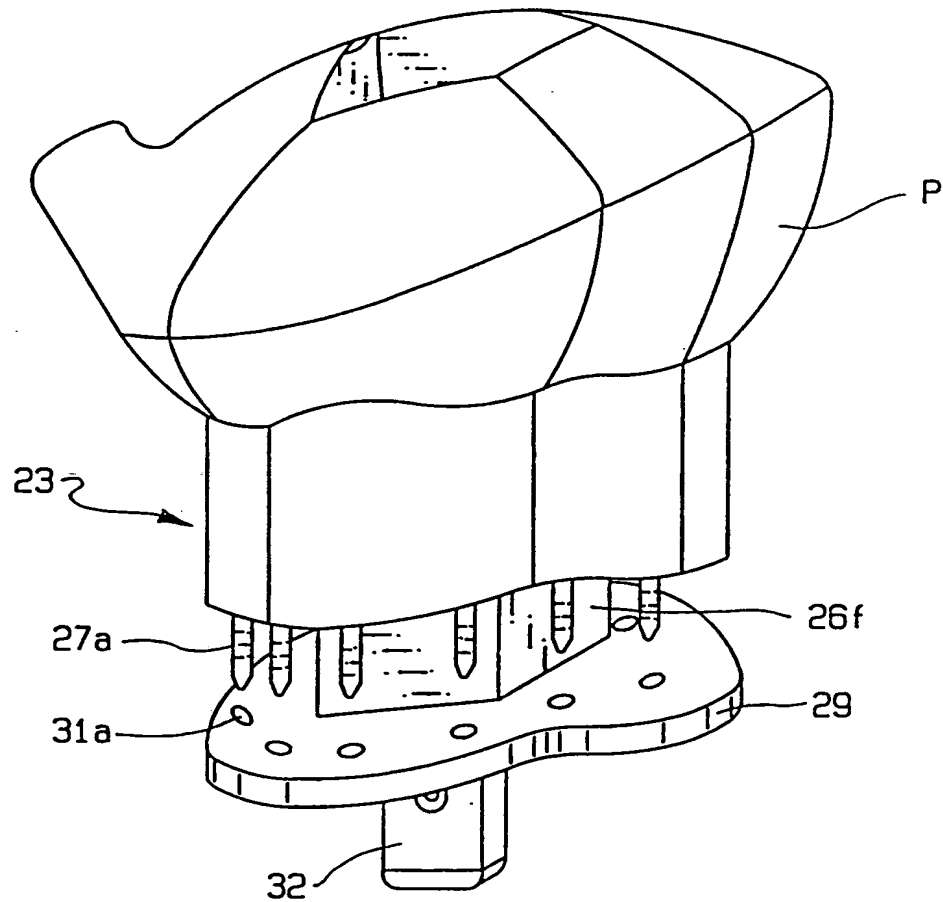


FIG. 7

6/14

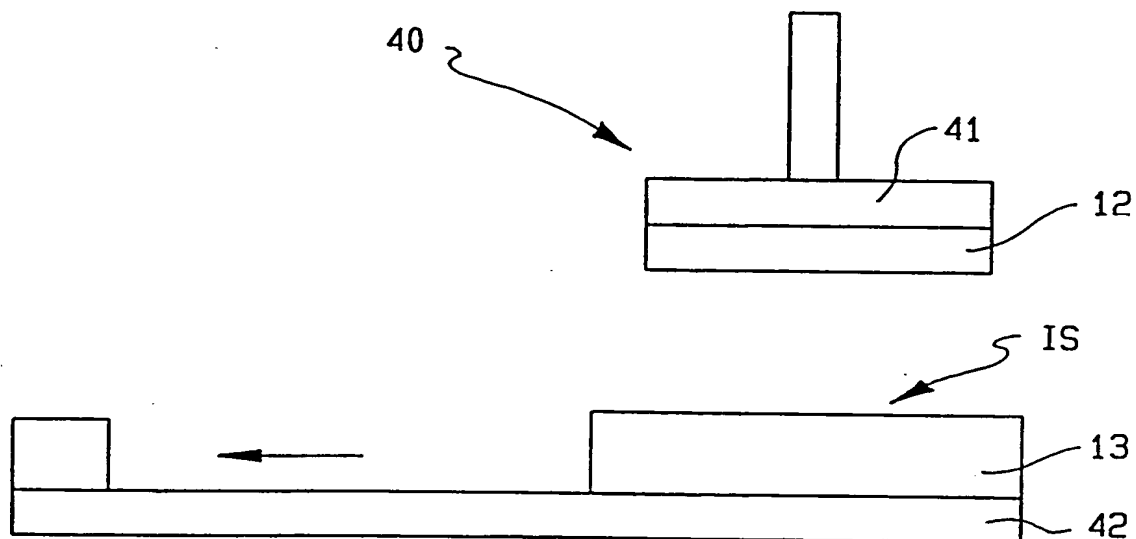


FIG. 8

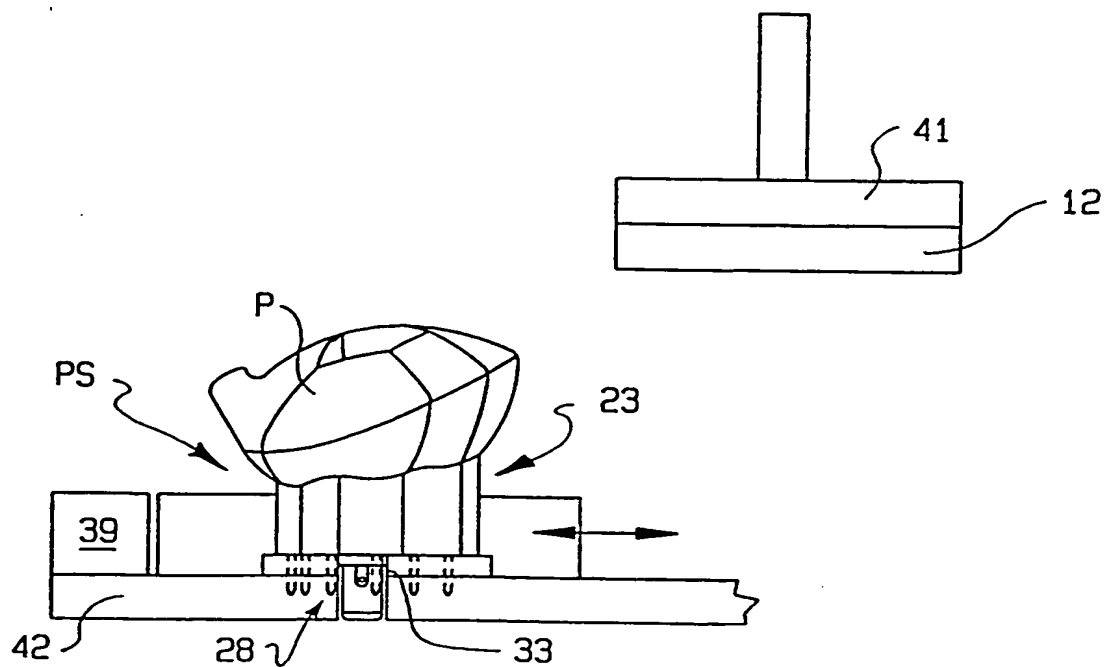


FIG. 9

7/14

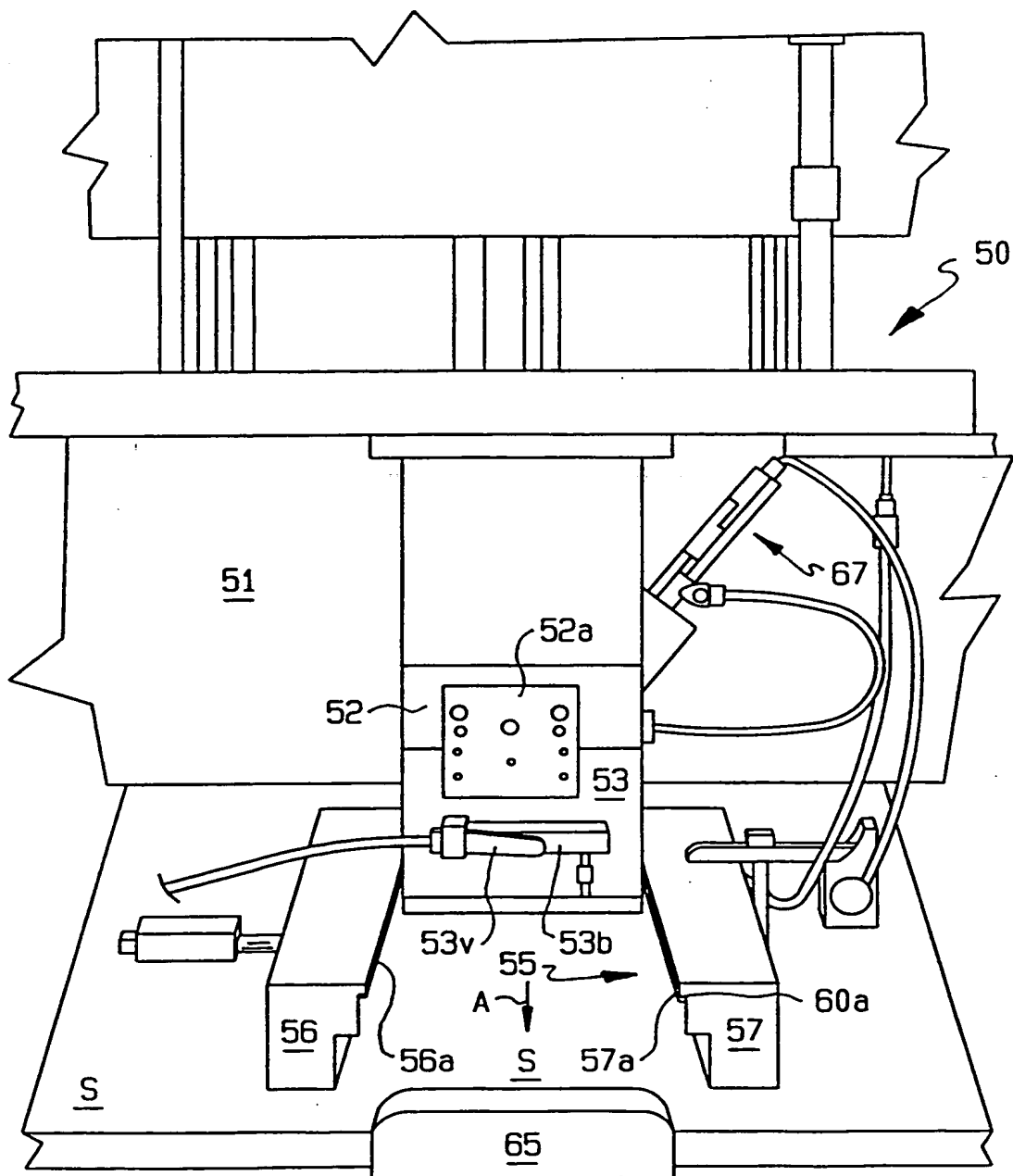


FIG. 10

8/14

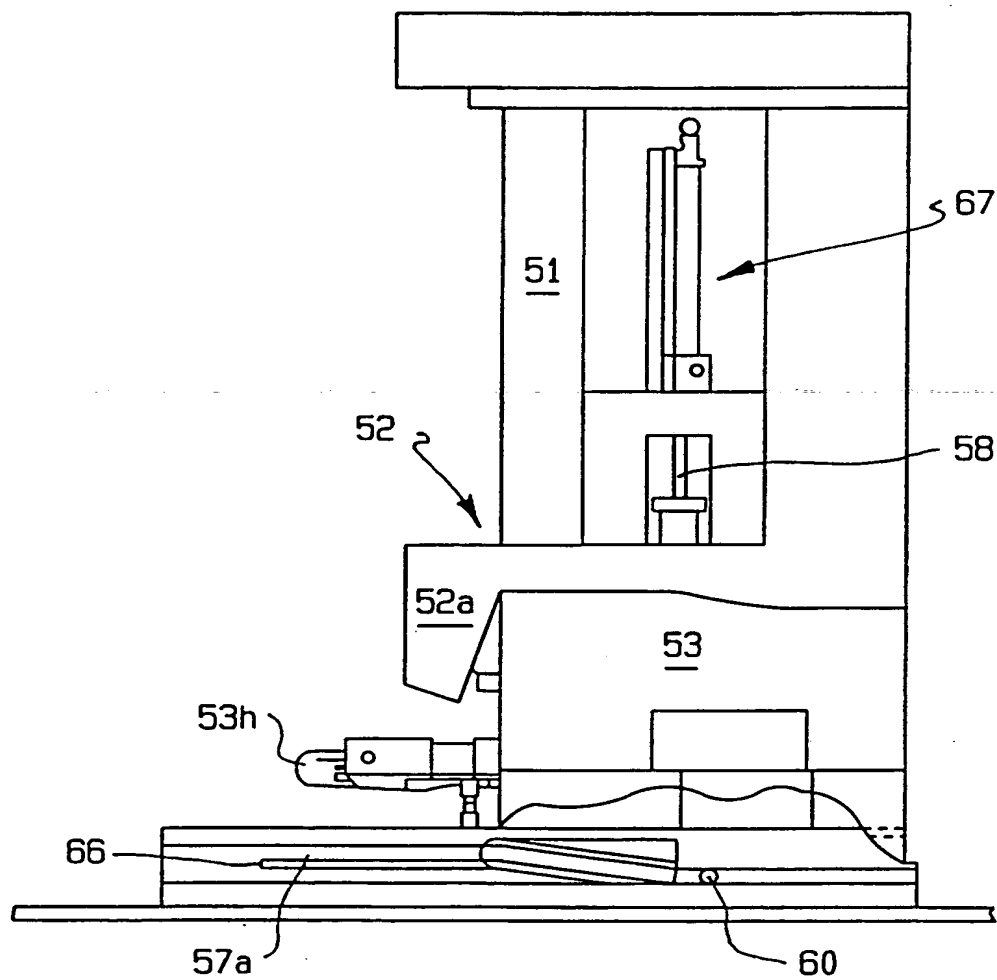


FIG. 11

9/14

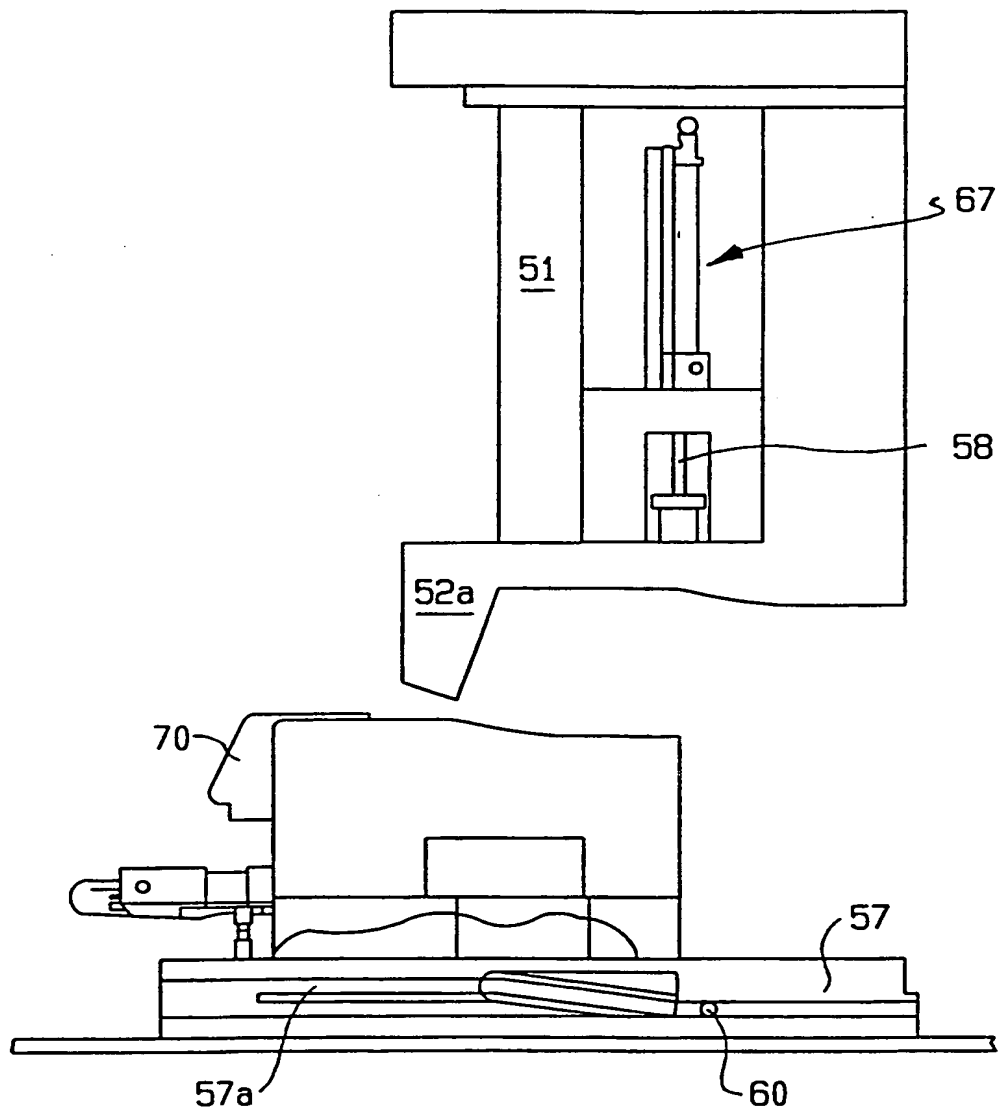


FIG. 12

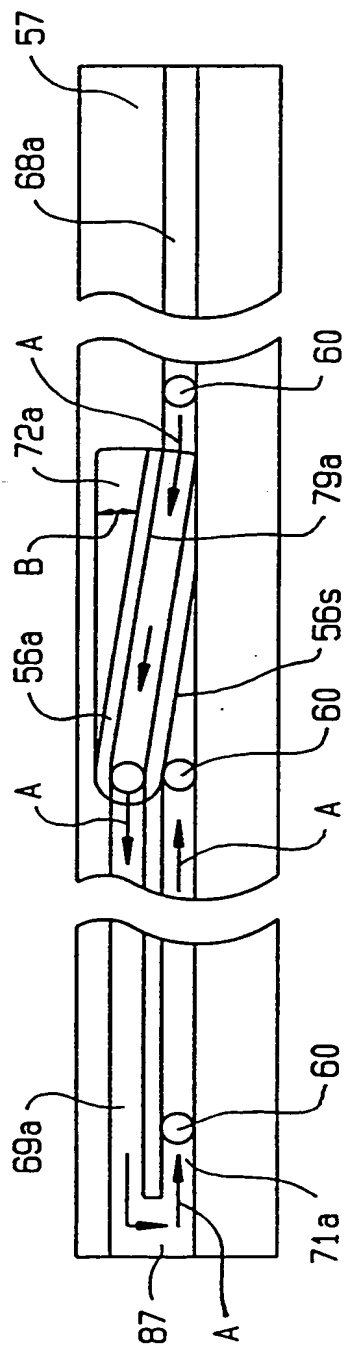


FIG. 12a

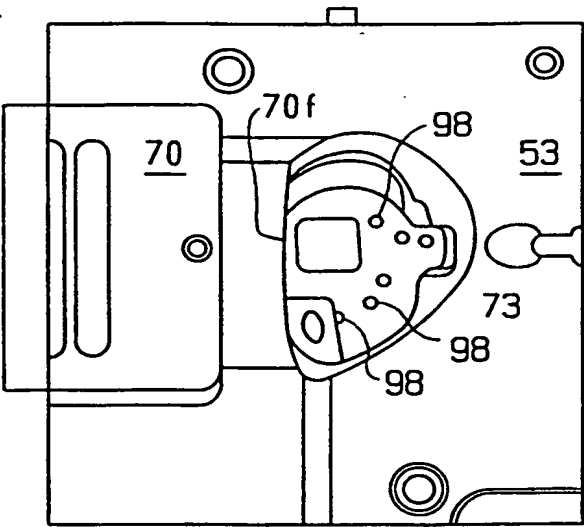


FIG. 13

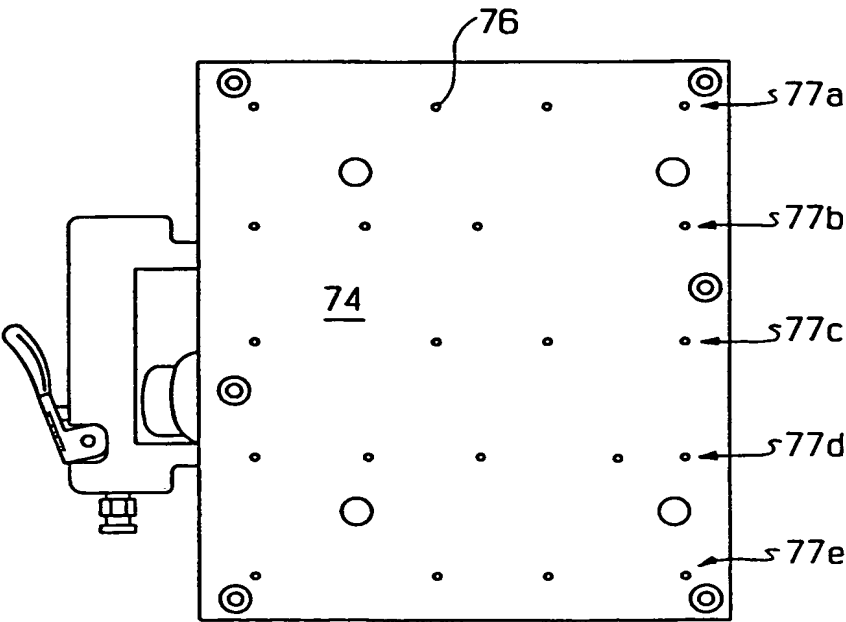


FIG. 14

12/14

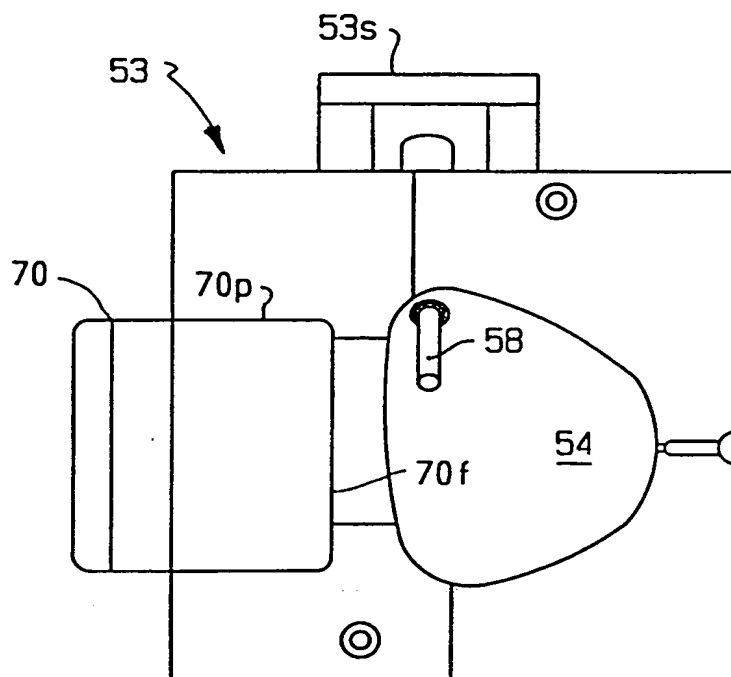


FIG. 15

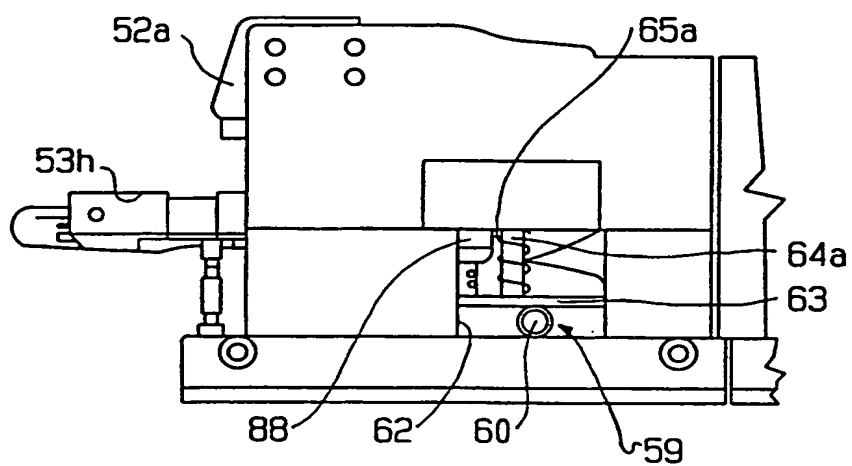


FIG. 16

13/14

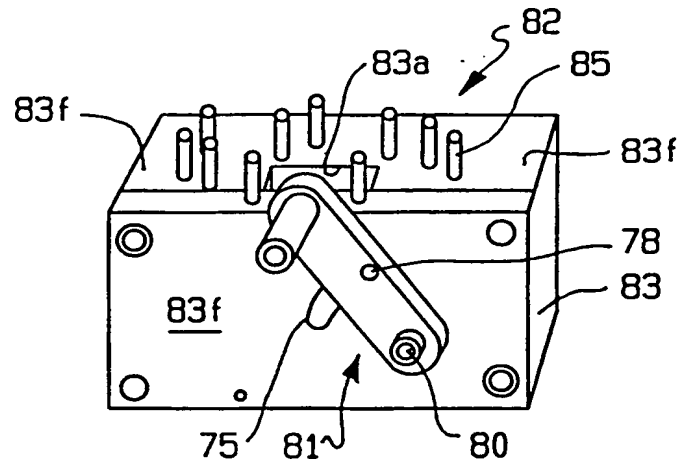


FIG. 17

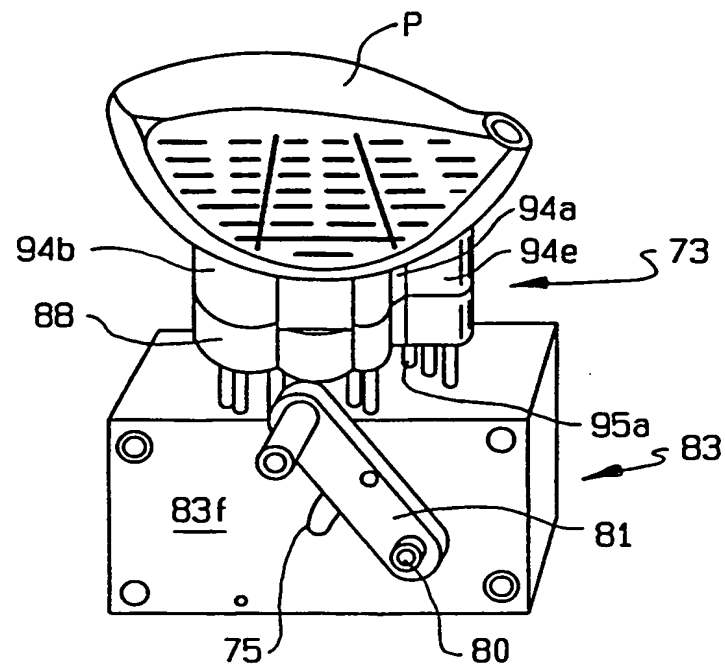


FIG. 18

14/14

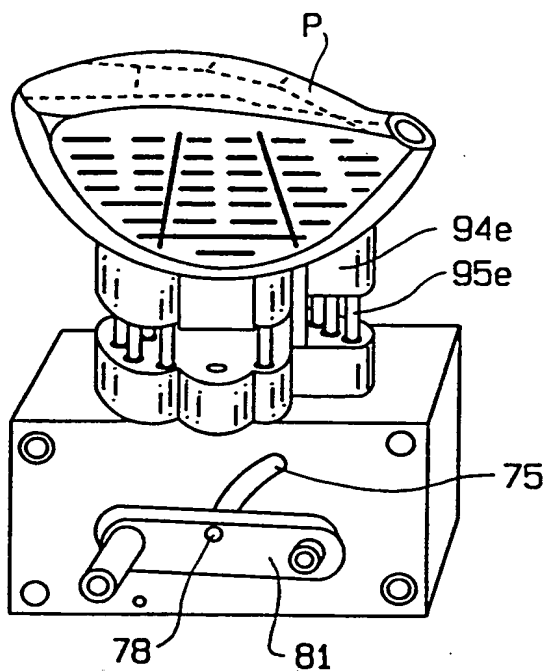


FIG. 19

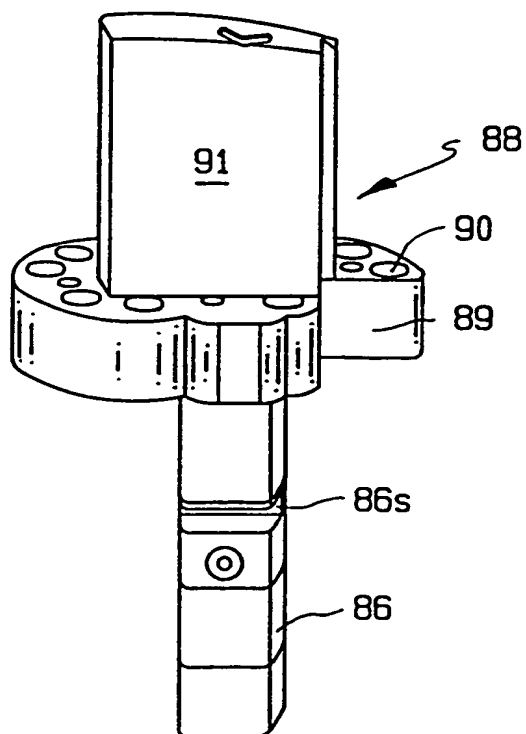


FIG. 20

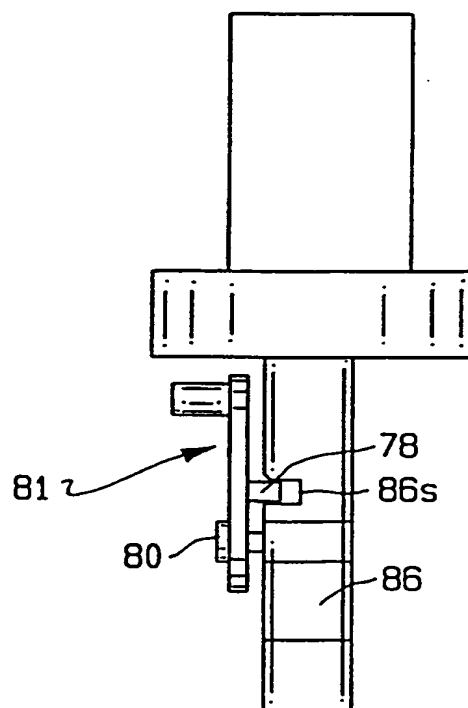


FIG. 20A

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US98/19160

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) :B29C 45/37

US CL :425/128, 183, 190, 249

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 425/128, 183, 190, 249

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
NONEElectronic data base consulted during the international search (name of data base and, where practicable, search terms used)
NONE

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 4,993,475 A (YAMADA) 19 February 1991 (19-02-91), Fig. 3.	1-18
Y	US 5,204,046 A (SCHMIDT) 20 April 1993 (20-04-93), Fig. 5.	1-18
Y	US 5,066,213 A (FERINCZ) 19 November 1991 (19-11-91), Figs. 1-17.	5
Y	US 5,445,511 A (ITO et al) 29 August 1995 (29-08-95), Figs. 1-11.	9-13, 15



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
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"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"A" document member of the same patent family
"O" document referring to an oral disclosure, use, exhibition or other means	
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

07 DECEMBER 1998

Date of mailing of the international search report

14 JAN 1999

Name and mailing address of the ISA/US
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. (703) 305-3230

Authorized officer

TIM HEITBRINK

Telephone No. (703) 308-0651